

Date: Friday, 13/02/2009 1:09:06 PM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG EXTRUSION		
Job Number	: 45800					
Estimate Number	: 10305					
P.O. Number	:		Part Number	: D2423		
This Issue	: 13/02/2009	S.O. No. :	Drawing Number	: D2423 REV B1		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: / /	Type :	Drawing Revision	: B1		
Previous Run	: 44529		Material	:		
Written By	:		Due Date	: 28/02/2009 Qty: 500 Um: Each		
Checked & Approved By	:					
Comment	: Est G 04.09.02 Part Number D2423-108 changed to D2423KJ/J LM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
2.0	D2423P	Lug Extrusion
Comment: Qty.: 1.0000 f(s)/Unit Total : 500.0000 f(s) 8197 C 209/02/13 (sooof)		
3.0	PACKAGING 1	PACKAGING RESOURCE #1 1/9/3/2 56.0 PMS
4.0	QC6	DIMENSIONAL CHECK 209/03/18 PTO
5.0	PACKAGING 1	PACKAGING RESOURCE #1 1/9/3/2 56.0 C60
6.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE 09/03/19 JH		

Job Completion



mf
09-03-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/03/18	1.0	Cut a sample piece to check with webster hardness tester. Readings were 15-16.5 Not a perm change, just a note.	/p	09/03/18	Sample	FJG 09/03/18	P 09/03/18

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

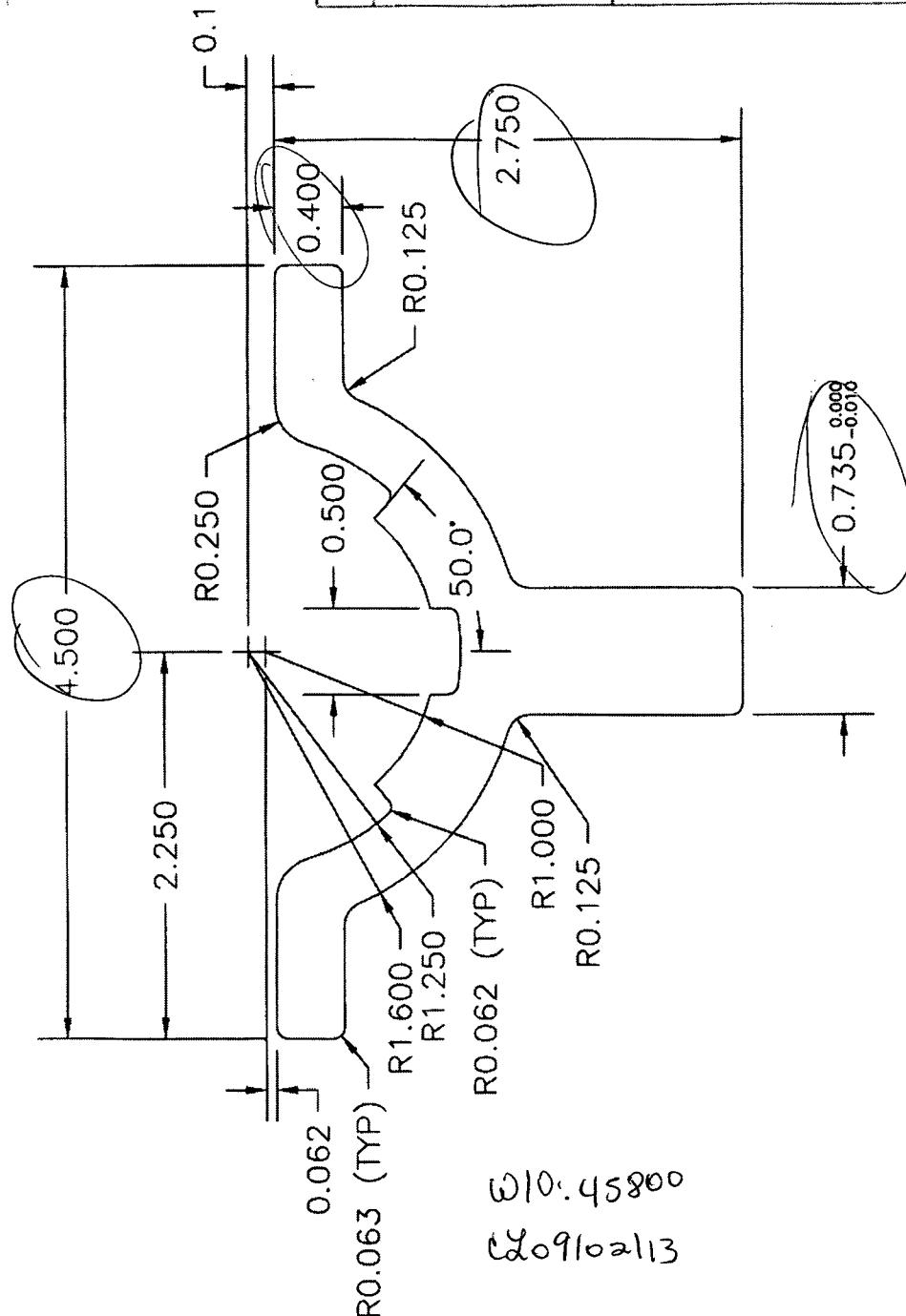
NOTE: Date & initial all entries

DART



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RP</i>	APPROVED <i>JL</i>	DRAWING NO. D2423	REV. B SHEET 1 OF 1
DATE 98.08.04		TITLE LUG EXTRUSION	SCALE 1:1
A	95.05.09	NEW ISSUE	
B	98.08.04	6061-T6 WAS 6005A.T5	
B1	01.04.17	ADDED NOTES 4+5 <i># (P)</i>	

RELEASED
98/08/06 KE



1. MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8)
2. NOTE: ALL DIMENSIONS ARE IN INCHES
3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4. MANUFACTURED USING CANTON INDIALEX DIE # M5-12866
5. PART NUMBER IS D2423-XXX WHERE XXX IS CUT LENGTH IN INCHES (es. D2423-108 IS 105" long)



ACCT# 00046024

SHIP TO
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CN

PHONE 613-632-5200

SOLD TO / PURCHASER
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CN

PHONE 613-632-5200

INVOICING COMPANY AND LOCATION
SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

REFER TO
 THESE NUMBERS ON
 ALL CORRESPONDENCE

CREDIT REP
 HAMBROOK, PAU
 905-508-3250

SALES REP

CUST SERVICE REP
 Burton, D
 905-427-2227

TERMS / FREIGHT
 O / P

LOCATION
 PIC 57364
 SALESMAN
 59358

FIELD SALES REP
 Kutter, A
 450-435-6551

BILL OF LADING NUMBER
 08389455

CUSTOMER ID
 46024 ORDER DATE
 02/13/09 CUSTOMER PO NUMBER
 8197

JOB

ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT:	PREVIOUS SHIPPED QUANTITY	MFG. PART NUMBER	ALLOY & TEMPER	FINISH DESCRIPTION	THIS SHIPMENT			UNIT	QUANTITY DUE
							LENGTH	FABRICATION DESCRIPTION	NBR OF PKGS		
				CUSTOMER PART NUMBER	CUTTING TOLERANCE	SHIPPING TOLERANCE	SHIPPING TOLERANCE				
01	63	KG M PC	0 0 0	DAA-5-2 D2423P	6061 /T6 8' +3/16 " -0 "	MILL CERTIFICATE OF COMP (+015-015,0072-0053)	2	954	940 170.69 70	KG M PC	0 0 0
				LOT/TKT DETAIL:		43757010 / 305303 43757010 / 305304	1 1	477 477	470 470	35 PC 35 PC	70x8 =560/12

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.

No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

PAGE 1

2	954	940 170.69 70	KG M PC
TOTALS			

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8

Part Date	Cart. No.	Sales Order	Page
03/01/09	188040	43757	1
03/01/09	08389455	43757010	Date
8197	08389455	43757010	3/01/09

Ship To:	Ship To:
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No.	Part No.	Item Description	Cust Part
1.000	DAA-5-2	8' MILL 6061 T6	D2423P
Gross Weight	954 KGS		
Net Wt.	940 KG	70 PC	171 M
Specification			Die Desc
ASTM B221-08			

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift	HREW
1	301.4 / 43.7	282.2 / 41.0	14.4	.0	92	

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI
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.65	.29	.26	.06	.88	.06	.04	.02
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This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

Conchita Ko, QA Manager Signature Aluminum Canada Inc

